

readily understood by comparing the jig with the work. After the drilling operation has been completed, it is a simple matter to release the work from the jig by pushing down the handle *D* and withdrawing the piece from under the bell-mouthed bushing. Drill Jig for Fork Links. — The drill jig shown in Fig. 8 was designed for drilling fork links. The form of these links is indicated by dot-and-dash lines in both views. The link has a round boss at one end and rounded forks at the other end. It

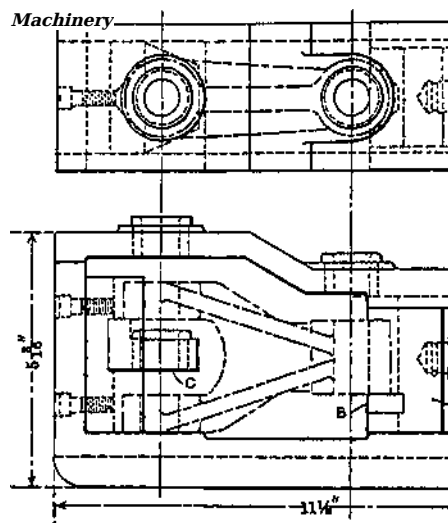


Fig. 8. Drill Jig for Fork Links

is accurately held between two V-blocks, one being adjustable and the other stationary. The adjustable V-block *A* is clamped against the work by the star-wheel and screw shown, and it

travels between finished ways, thus providing an accurate as well as rapid method of clamping. These V-blocks have inserted steel plates *B* and *C*. The latter, which is in the stationary V-block, carries a drill bushing for drilling the lower fork, and an upper shoulder on this plate provides a support for the upper fork; thus there are two bushings in alignment for drilling the two ends. The inserted plate *B* in the adjustable block supports the opposite end of the fork link. With this arrange-